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1- scale print of THOMPSON SUB MACHINE GUN M1A1

1- scale print of MK 1 and MK 1* LANCHESTER

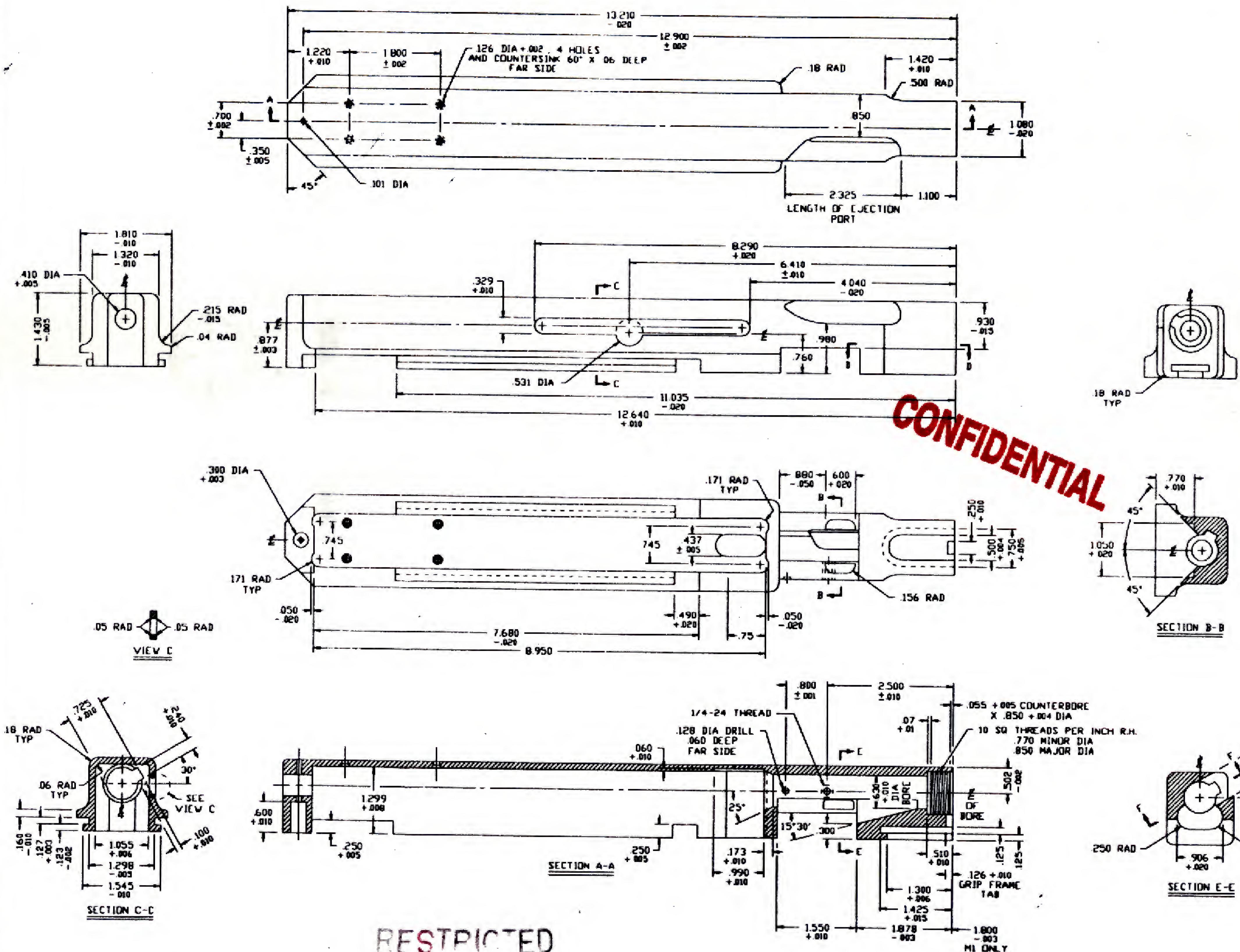
1- scale print of MODEL 37 right and left side plates

1- scale print of UD-M42

PARTS SUPPLIERS ON LAST PAGE

NOTES

1. MATERIAL - FS1340, FS2330 (FED SPEC QQ-S-624)
2. FINISH - TYPE II CLASS A (SPEC USA S7-0-2)
3. HARDNESS - ROCKWELL A615-70.5
4. HEAT TREATMENT - HEAT 1350° LEAD POWDER CN IN NOTCHES, COOL REHEAT 1350° 1.5 MIN, OIL QUENCH, DRAW 930°

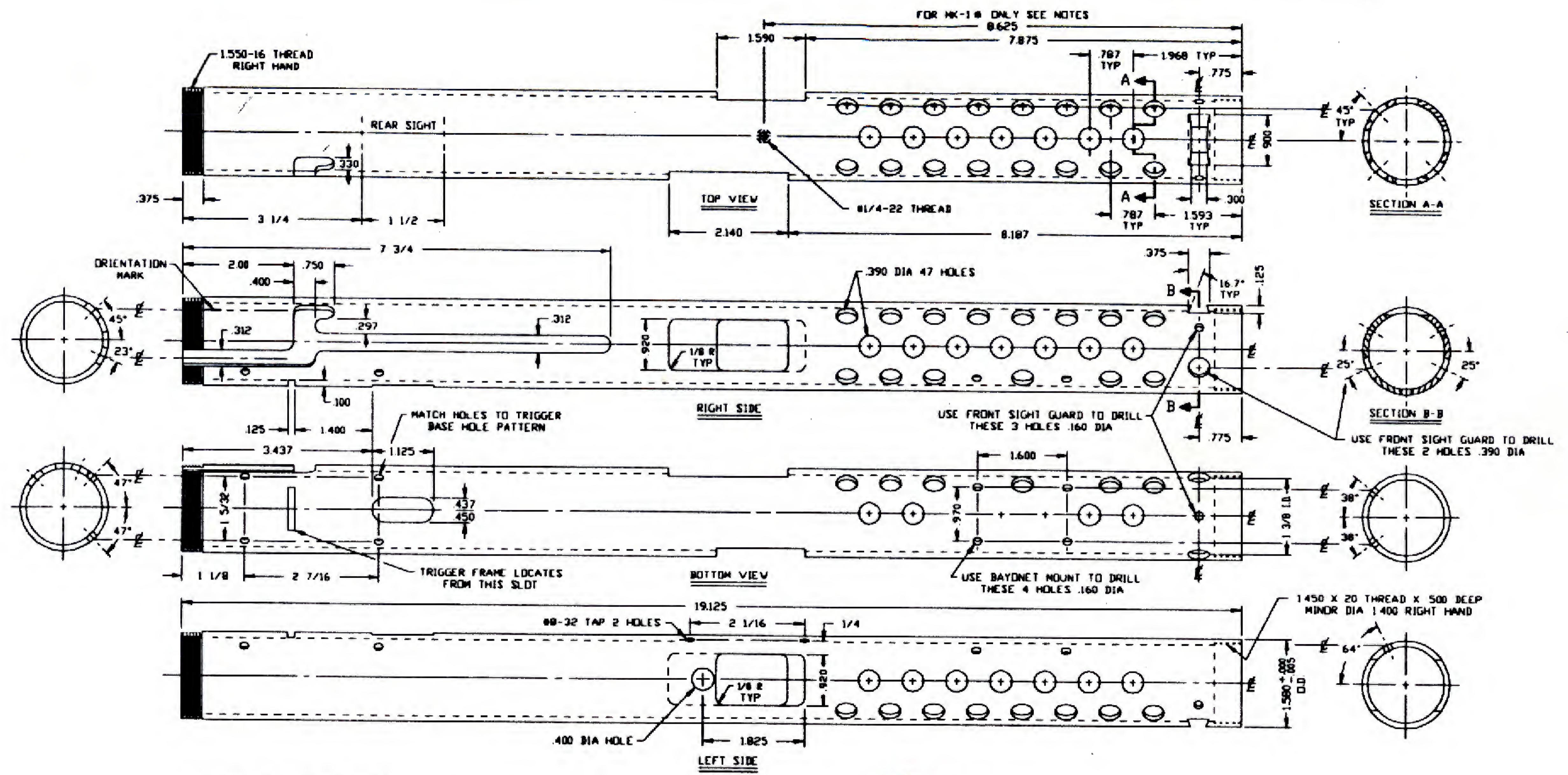


RESTRICTED

7/14/81

SCALE	FULL	MATERIAL	CKB	TOLERANCES
INCH		SEE NOTE 1		DEC 2 PL 2
INCH		FINISH SEE NOTE 2		DEC 3 PL 2
INCH				DEC 3 PL 2
INCH				ANGLE 1 8°
INCH				RD

NOTE: THOMPSON SUBMACHINE GUN MODEL M1A1



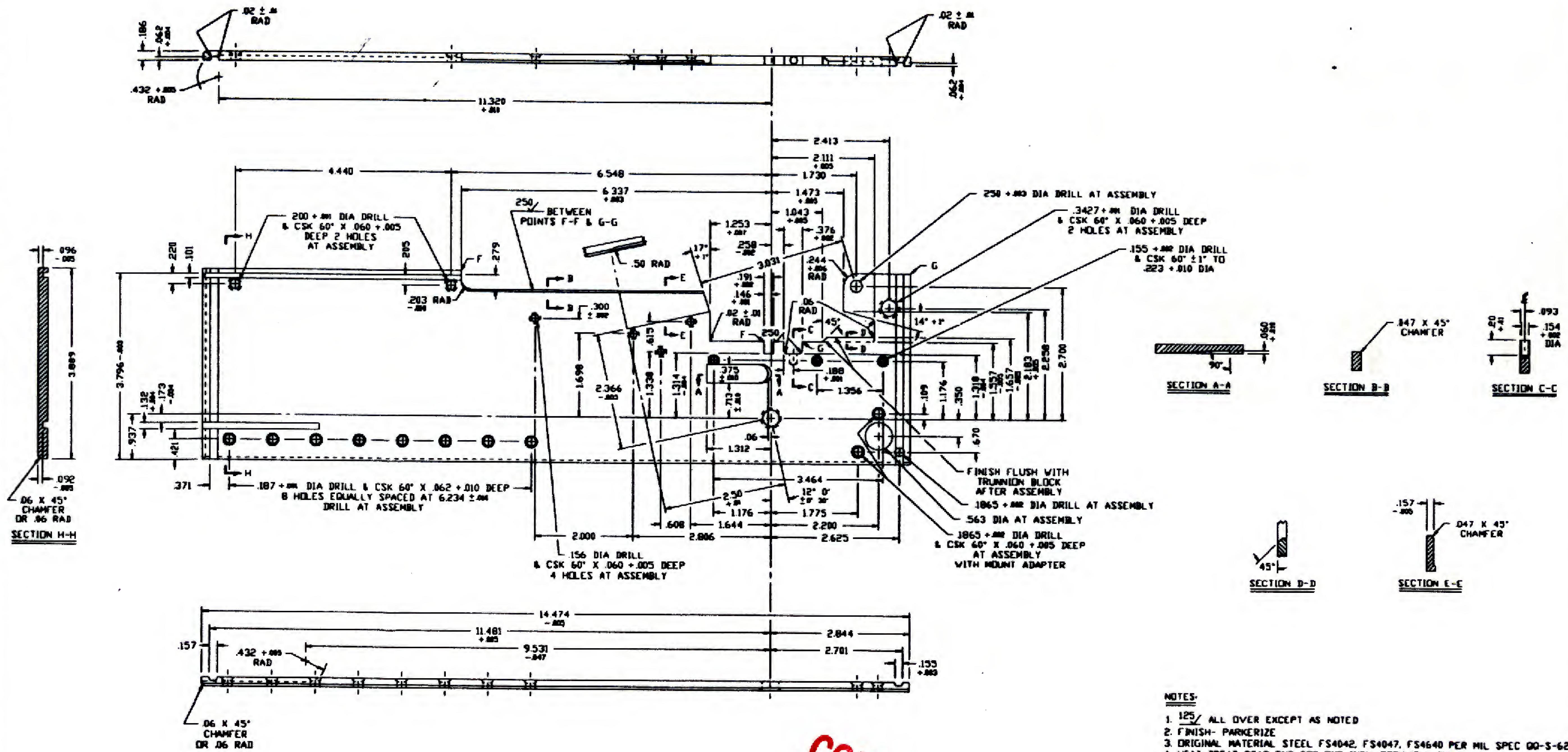
GENERAL NOTES AND SUGGESTIONS

1. TURN OLD AND THREAD BOTH ENDS FIRST.
2. MARK 1 # IS THE LATER MODEL, FULL AUTO, AND HAS 1/4-22 SCREW IN TOP OF MAGAZINE HOUSING THAT LOCKS BARREL IN PLACE.
I TAP THIS HOLE & MAGAZINE HOUSING 1/4-20 AND USE ORIGINAL SCREW OR MAKE ONE
3. ALL .160 HOLES WERE ORIGINALLY RIVET HOLES. I DRILL THESE HOLES #29 (.136) AND TAP #8-32 USE #8-32 X 1/4 ROUND HEAD MACHINE SCREWS.
4. WITH END CAP IN PLACE TIGHT, BACKOFF 1/8 TURN AND MAKE A LINE-UP MARK ON BOTH PARTS
PLACE TUBE IN STOCK AND LOCK END CAP IN PLACE. SLIDE MAGAZINE HOUSING ON TUBE AND LOCATE IN STOCK AND INSTALL HINGE SCREW. SPOT DRILL THRU MAGAZINE HOUSING FOR 2 #8-32 SCREWS. DRILL #29 AND TAP #8-32 AND INSTALL 2 #8-32 SCREWS, THE ORIGINAL ONES FIT. THIS ESTABLISHES THE HOUSING TO THE END CAP ALL OTHER HOLES ARE RELATIVE TO THE 2 PARTS.
5. LOCATE ALL OTHER HARDWARE BY SPOT DRILLING IN PLACE.
6. MAIN PORTS CAN BE SORIBED WHILE HOUSING IS IN PLACE. EXTRACTION PORT SIZE IS CORRECT, BUT MAGAZINE HOUSING HOLE IS LARGER.
7. THESE DIMENSIONS WERE COMPILED FROM 3 LANCHESTER RECEIVERS.
8. FRONT SIGHT DOVETAIL IS NOT A STANDARD TAPER MACHINE A STRAIGHT SLOT AND TRIM FRONT SIGHT TO FIT AND SOLDER IN PLACE.
9. FINISH BLUE ALL STEEL PARTS. BRASS SHOULD BE NATURAL, NOT PAINTED.
10. BAYONET: ENFIELD P1907 LONG OR P1907/42.
11. MATERIAL: 1 5/8 O.D. X 1 3/8 I.D. DOM 1020 STEEL TUBE.

CONFIDENTIAL

PREFECTURED

SCALE FULL	MATERIAL SEE NOTE 11	CDR	TELEGRAMS
DATA	FINISH SEE NOTE 9	DATE	REC 2 P.M. ± 30' REC 2 P.M. ± 30'
TITLE. MK-1 & MK-1A LANCHESTER RECEIVER	REV.	REC 3 P.M. ± 30' REC 3 P.M. ± 30' WADS ± 5'	



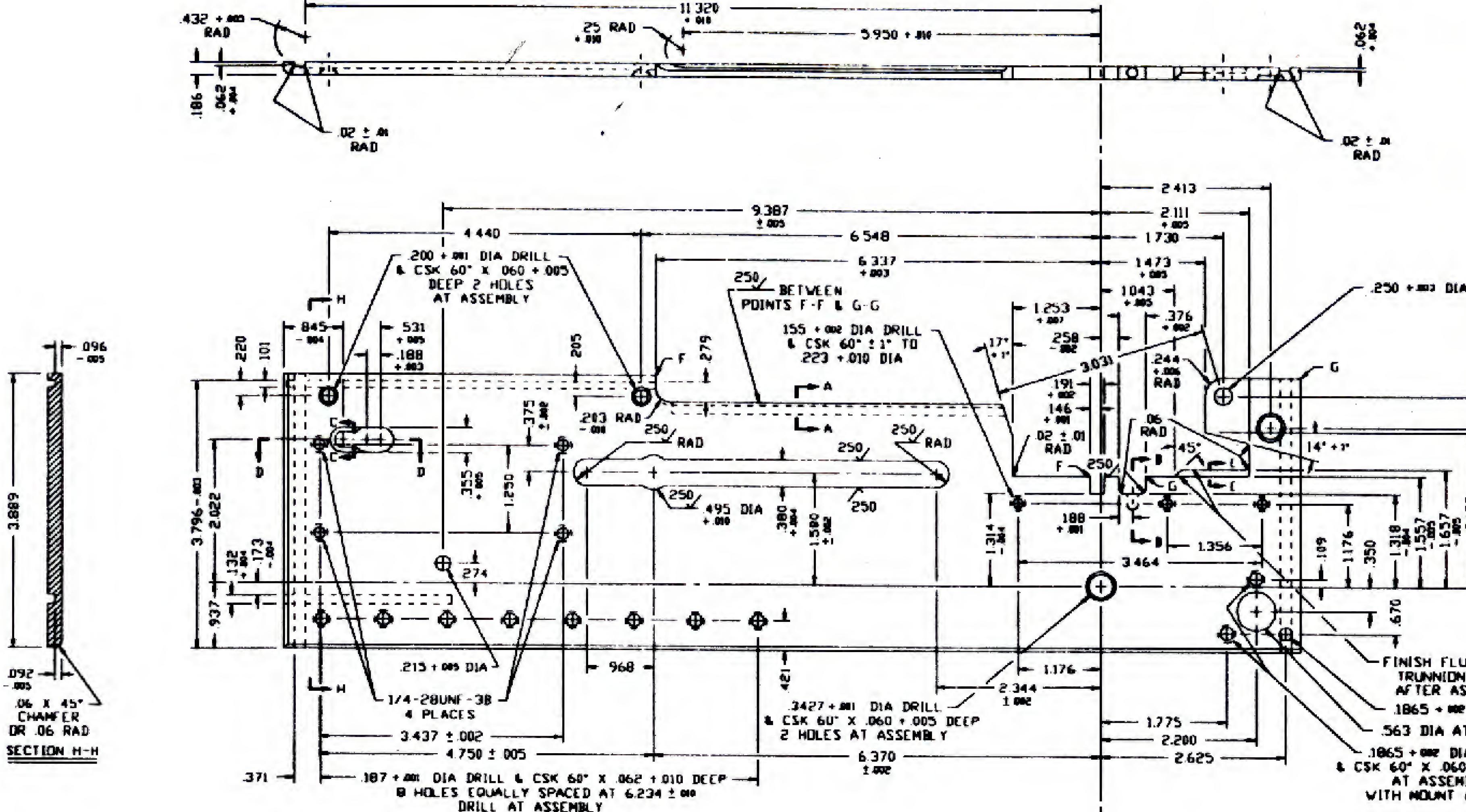
RESTRICTED
MATERIAL

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DRAWN FROM ORD. PART NO. 7100702
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL.

WEIGHT FULL	WEIGHT LIGHT	WEIGHT HEAVY	TOLERANCES
INCH	INCH	INCH	INCH
INCH	INCH	INCH	INCH
REV.	REV.	REV.	REV.

MODEL 27
LEFT HAND SIDE PLATE



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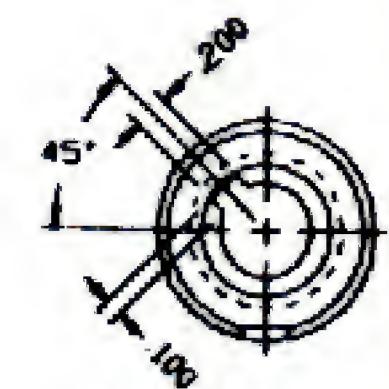
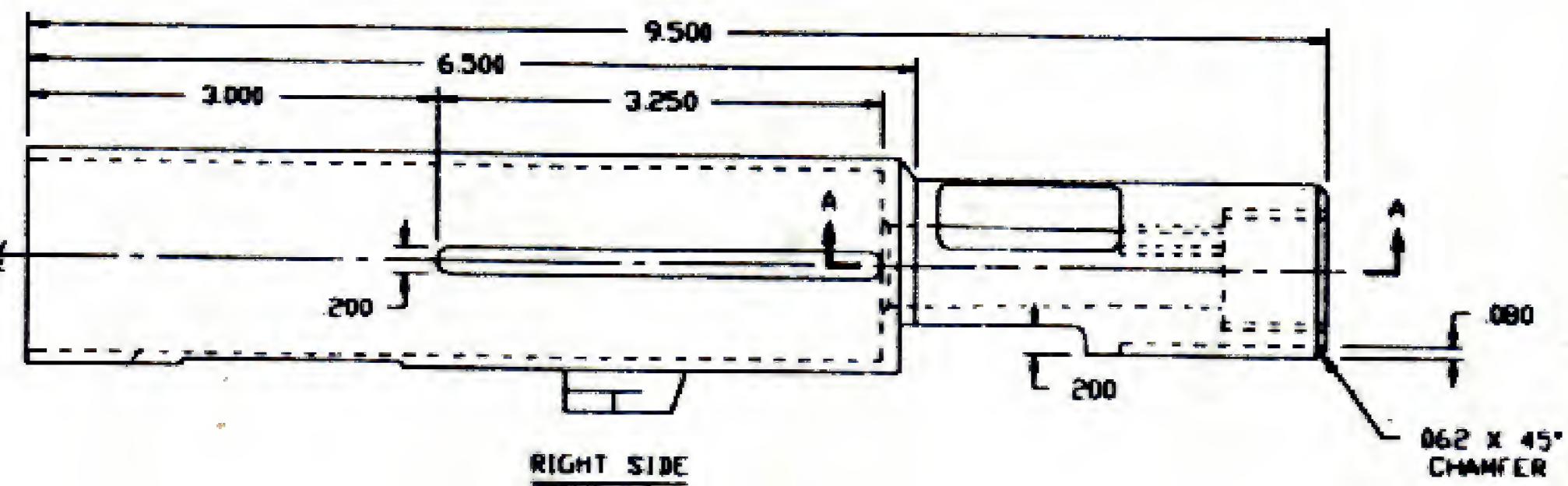
**RESTRICTED
MATERIAL**

ANSWER

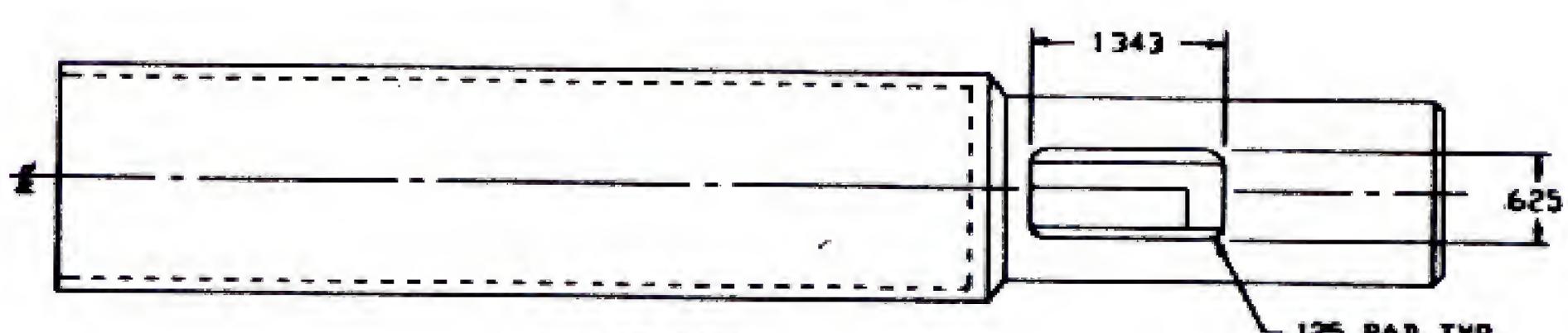
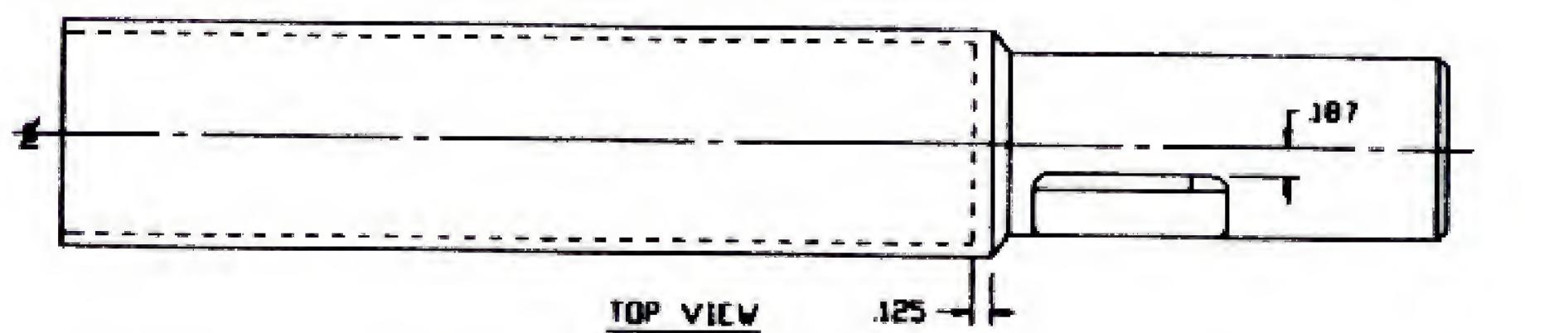
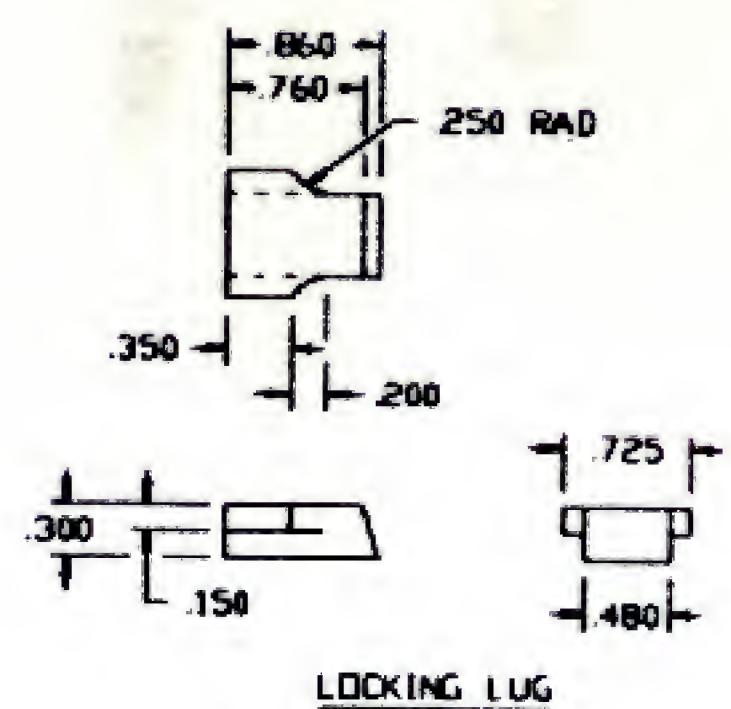
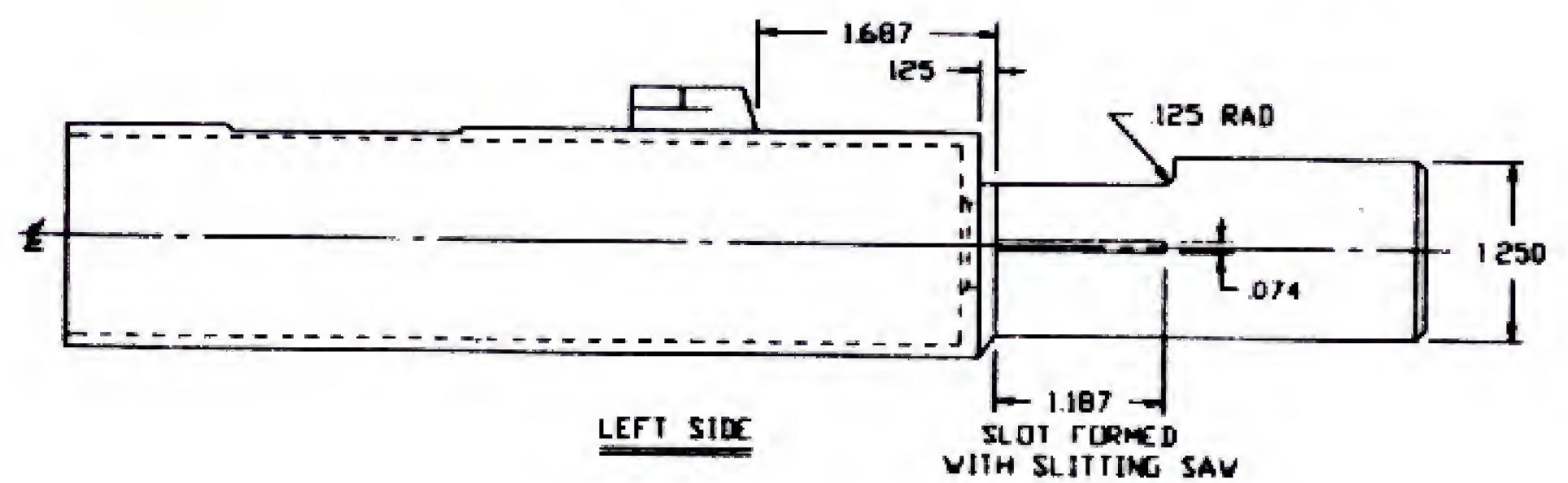
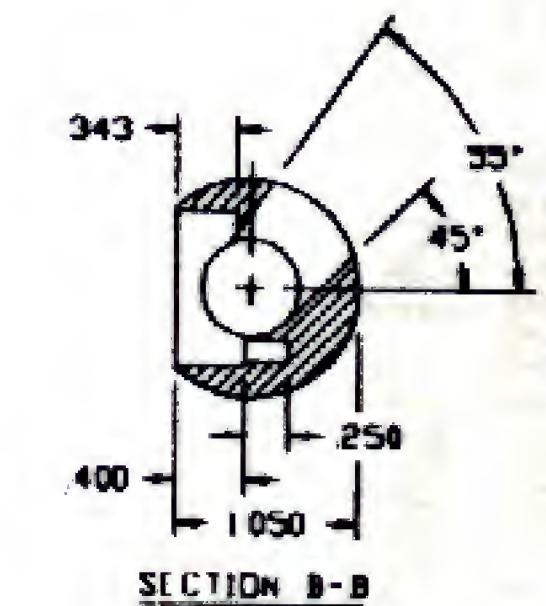
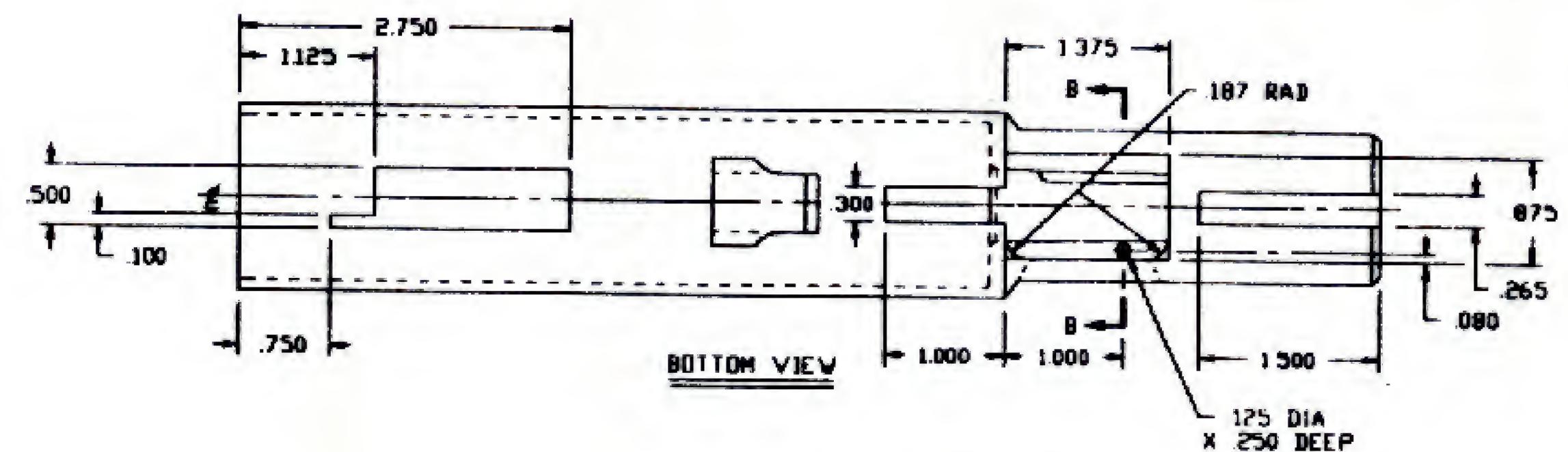
1. 125/ ALL OVER EXCEPT AS NOTED
2. FINISH- PARKERIZE
3. ORIGINAL MATERIAL STEEL FS4042, FS4047, FS4640 PER MIL SPEC QQ-S-624
4. HEAT TREAT REAR END FOR ONE INCH ROCKWELL "C" 43-49
ANNEAL AROUND FOUR HOLES

DRAWN FROM ORD. PART NO. 0414730
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL.

SCALE FULL	MATERIAL SEE NOTE 3	CAB	TOLERANCES
SIZE	FINISH SEE NOTE 2	DATE	DEC E PL. $\pm \frac{.05}{.03}$ H H 2 PL. $\pm \frac{.05}{.03}$
TITLE	REV.		DEC 3 PL. $\pm \frac{.05}{.03}$ H H 3 PL. $\pm \frac{.05}{.03}$
MODEL 37 RIGHT HAND SIDE PLATE	NO.		ANGLE 3 : 5°



SECTION A-A
TAPERED BOLT HOLE



WITH EXTRACTION PORT
ROTATED 45°

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NOTES:

1. MATERIAL - COLD ROLL, HOT ROLL, 4130, 4140 OR 4340 STEEL
2. FINISH - BLUE
3. HEAT TREATMENT - 4130, 4140, 4340 28-32 R/C

RESTRICTED
MATERIAL

SCALD FULL	MATERIAL SEE NOTE 1	C.R.	TOOLANCES
INN	FINISH SEE NOTE 2	DATE	REC
TITLE: UD-M42 RECEIVER		REV.	ANGLE
			REC

LIST OF PARTS SUPPLIERS

wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722

www.gunsnammo.com

international military antiques , inc.
p.o.box 256 millington ,NJ 07946

www.ima-usa.com

inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110

www.inter-ordnance.com

sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980

jeffs shooters supply
p.o.box 1054 trussville , AL 35173

rpb industries
p.o.box 367 avondale est. GA 30002